

542

SPLIT u

DART AEROSPACE LTD	Work Order:	24417 A
Description: Wearpad	Part Number:	D3429-1
Drawing: D3429 Rev. A	Qty:	100 20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AB	05/10/06	100
2	PG	Issue P/O: 2008782 Email or ship DXF file to vendor Laser Cut D3429-1 Flat pattern as per Dwg D3429 Material release note required	AB	05/10/06	100
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached	CL	05/10/13	100
4	QC6	Inspect dimensions as per template D3429-1T1	2	05/11/10	100 PTD
5	GB	Deburr if necessary	N/A		
6	GB	Form on Brake as per Dwg D3429 using Jigs DT8261 and DT8326. Identify as D3429-1	SB	05/11/10	100
7	GB	Form Joggle as per Dwg D3429 on brake using Jig DT8158	SB	05/11/10	100
8	WS	Weld hardcoat as per Dwg D3429 Qty Description Batch A/R 7560Hardcoat 119172	CP	05/12/12	20
9	QC9	Inspect weld	AA	05/12/12	20
10	QC5	Inspect work to Step 9	ML	05/12/13	20
11	FP	Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3	FC	05/12/13	20
12	QC3	Inspect Powder Coat	ML	05/12/13	20
13	FP	Identify and Stock	ML	05/12/13	20
14	AC	Cost / part:	JAC	05/12/14	20
15	DC	Close W/O Inspect Level 21	PD	05/12/14	20

Rev	Date	Change	Revised By	Approved
A	05.10.04	New Issue	KJ/EC	EC

RELEASED
05.10.05



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TEST CERTIFICATE

Ref: 5078/21768

CUSTOMER	Wilkinson	P50128DI003	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC109561
CUSTOMER O/N	90-21N-540		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL O/N	471159		DIMENSIONS	0.055" x 48" x Coil	DATE	23 April 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)							
		C	SI	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000												x10000	x100	180°			GL=	HRB	()
R9-457097-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562
R9-457098-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1483
R9-457099-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562
R9-457100-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1496
R9-457101-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1562
R9-457102-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1555

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=r0 (C)=r45	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/6
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65 / So (F)=8"	(B)=r90 (D)=(r0+r90+2r45) / 4	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15
					(C)=C+Mn/6+Si/24
					(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

16 ga crms

